

W/Jet 7355



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V3021132-5
Job Sheet 180238



Part No: RBEM632V3021132-5

Job Qty: 6 ea

Part Name: Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/3/18

Job Tracking No:

Due Date: 8/13/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3021132 Rev. 2 IPP Rev. A 18.06.27 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Waterjet2		OK 18/08/18
100	Waterjet	6 pcs	8/13/18	8/13/18	0.00	0.60	Waterjet 2 OMAX		OK 18/08/18
110	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC2 Waterjet-4		OK 18/08/18
120	Small Fab	6 pcs	8/13/18	8/13/18	0.50	0.50	Small Fab-7		MLD 18/08/18
140	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC5		AUG 17 2018 38
150	Outsource	6 pcs	8/13/18	8/13/18	0.00	0.00	Outsource13		OK 18/08/18
160	Packaging	6 pcs	8/13/18	8/13/18	0.00	0.00	Packaging2		AUG 27 2018 38
170	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC6		OK 18/08/18
180	Powdercoat	6 pcs	8/13/18	8/13/18	0.00	0.60	Powdercoat13		OK 18/08/18
190	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC3		SEP 06 2018 68
200	Small Fab	6 pcs	8/13/18	8/13/18	0.00	0.50	Small Fab-9		MLD 9-89
210	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC5		38
220	Packaging	6 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3-2		MLD 9-89
230	QC21-SA	6 Ea	8/13/18	8/13/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per DWG. DWG. Rev: 2 PROG. Rev: 2 2-Deburr if necessary
Descriptions: 120 - 1-Ream holes using 5mm. reamer only if required. 2-Tap holes as per DWG.

150 - Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4130 -Certificate of Conformity is required

160 - Receive

180 - START TIME: 7:35 OVEN TEMPERATURE: 350° FINISH TIME: 8:05 No powder coat on this surface as per note 3.

200 - Laser engrave T/N as per DWG.

220 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.125	4130 Sheet .125 (11Ga)	1.4640 sf (.244 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NS.125	1	6	0



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S102090



Part: RBEM632V3021132-5

Job No: 180238

Serial No/Batch: S102090

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 08/14/18

AUG 1 2018

8105 2800A

83

SEP 0 2018

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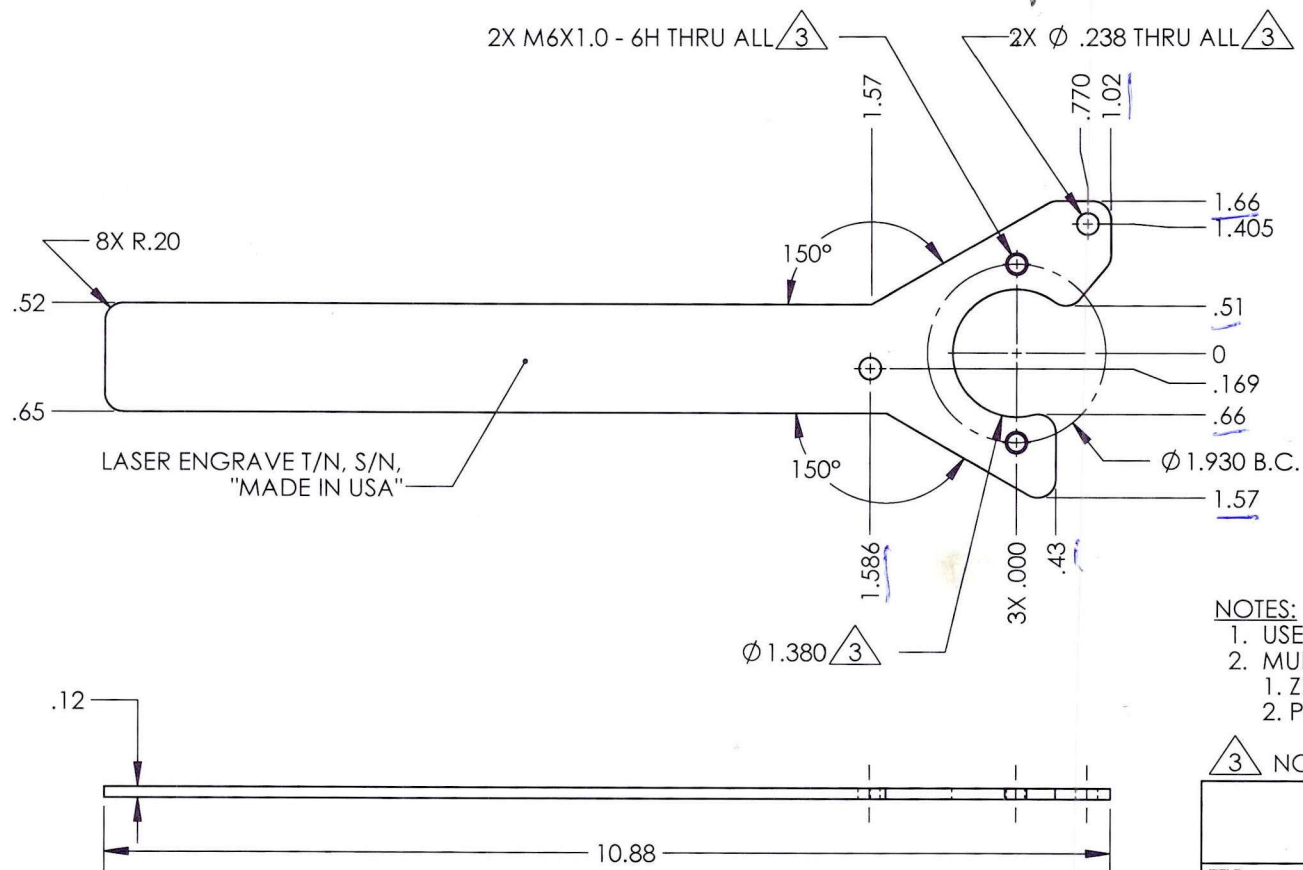
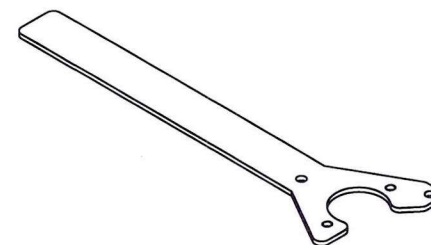
OCT 0 2018

Part Specifications
Specifications could not be found.

Plex 8/8/18 5:22 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0014	-5 ADDED NOTE LASER ENGRAVE T/N, S/N, "MADE IN USA".	1/24/2017	RJC	JAG



NOTES:

- USE CAD DATA FOR MANUFACTURE.
- MULTIPLE FINISH:
 - ZINC PLATE SPEC: ASTM B633 TYPE 1 SC2.
 - POWDER COAT YELLOW SPEC: FED # 13538.

(3) NO POWDER COAT ON SURFACE.

DART
AEROSPACE

TITLE			NUT KEY	
DWG NO.	RBEM632V3021132-5			REV 2
MAT'L 4130	UNLESS OTHERWISE SPECIFIED			
HEAT TREAT	DIMENSIONS ARE IN INCHES			
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8			
SPEC FED #13538	.XX ± .01 ANGLES ± 5°			
	.X ± .1 SURFACES = 125/✓			
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES			
CHECKED: CLOUGH	.015 x 45° OR .015R			
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009			
APPROVED: GILBERT	USED ON MODEL			
	H175			
SCALE 1:2	DATE 3/3/2016	SHEET 4 OF 4		

(-5)

HANDLE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
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PURCHASE ORDER **PO040775**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040775
PO Date: 8/20/18
Due Date: 8/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180238	RBEM632V3021132-5	Handle -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4130 -Certificate of Conformity is required	Firmed	-	8/27/18	8 pcs	0 pcs	8 pcs	\$11.25/pcs	\$90.00
Grand Total:											\$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/24/18 10:50 AM dart.tsimiklis.chrisoula



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Revision:
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Ship-To Contact: Phone:

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Grand Total:											\$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
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Plex 8/20/18 1:46 PM dart.tsimiklis.chrisoula



FM-1020 Rev 2

Certificat de Conformité / Certificate of Compliance
(011945-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**011945 - 1**

Livré à / Ship to

DART AEROSPACE LTD1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.		
24-Aug-2018		Aman				040775		
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM632V3021132-5 Rev.	RBEM632V3021132-5 ZINC PLATE ASTM B633 TYPE I SC 2 COLOR- CLEAR	ZINC CH	8	8	0	0	0

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.



Certificat de Conformité / Certificate of Compliance

(011945-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
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Bon de Livraison / Packing Slip

011945- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.		
24-Aug-2018		Jessie Boisvert				040775		
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM632V3021132-5 Rev.	RBEM632V3021132-5 ZINC PLATE ASTM B633 TYPE I SC 2 COLOR- CLEAR	ZINC CH	6	6	0	0	0

Customer: DART Aerospace Ltd
 PO#: 040775
 PN#: RBEM632V3021132-5
 Qty: 8 Box: 1 Of:

Customer: DART
 PO#: 040775
 PN#: RBEM632V3021132-5
 Qty: 6 Box: 1 Of:

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
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